

# Work Order ID 104736

**\*104736\***

Page 1

Wednesday, July 17, 2013 10:55:00 AM

Item ID: D3371-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Tail Rotor Pedal Lock

Stop **\*NS2\***

Start Date: 7/17/2013 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 7/19/2013 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *13-7-19*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3371

Rev B

120

**\*120\***

Small Fab

*Key Alike*

0.00

Small Fab

Memo

0.00

Small Fab

ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.

2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer.

Discard the rest.

3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5

4- Assemble lock mechanism and cam and install decal as per Dwg D3371.

Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	<i>125715</i>

*125715*

130

**\*130\***

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble lanyard to cyclic sock as per Dwg D3384  
Identify as D3384-045

*3*

*Ø*

*FF*  
*13-07-18*

*3*

*Ø*

*FF*  
*13-07-18*

# Work Order ID 104736

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Item ID: D3371-041 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Tail Rotor Pedal Lock  
 Start Date: 7/17/2013 Start Qty: 3.00 \*3\* Cust Item ID:  
 Required Date: 7/19/2013 Req'd Qty: 3.00 \*3\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
*140*	Small Fab					3	0		FF 13-07-10
Small Fab	Memo	0.00							
Small Fab	1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371. 2- Identify as D3371-041 & attach keys 3- Record the Key Number on page 4								
150	QC5- Inspect part completeness to step on W/O	0.00							
*150*						3			DAS 0513-07-22 0-89
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location	0.00							
*160*						3x			SD 13-7-22
Packaging	Memo	0.00							
Packaging									

Clb C420A

**Work Order ID 104736**

Wednesday, July 17, 2013 10:55:00 AM

**\*104736\***

Page 3

Item ID: D3371-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Tail Rotor Pedal Lock

Stop **\*NS2\***

Start Date: 7/17/2013 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 7/19/2013 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept Reject Reject Insp.  
Qty Qty Number Stamp

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

MUS 13-07-22

MF

13-7-22

# Picklist Print

Wednesday, July 17, 2013 10:54:58 AM

Page 1

Work Order ID: 104736  
Parent Item: D3371-041  
Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/17/2013

Required Date: 7/19/2013

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028 3/16" Dowel Pin .5" long		Purchased	No			120	Each	134.0000	2	6		FF 13-07-18	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						GA	9						
						17848	9						
						ST396	125						
						106673	90						
						108114	35						
AN526C832R6 Screw		Purchased	No			120	Each	155.0000	4	12		FF 13-07-18	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST345	155						
						16612	155						
AN960-416 STEEL WASHER	NAS1149F0463P	Purchased	No			140	Each	0.0000	2	6		FF 13-07-18	
CBL-1240 Cable		Purchased	No			130	f	815.4819	1.6666	5.2629474		FF 13-07-18	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						GA	815.4819124						
						113565	3.911789						
						119690	381.00006						
						122190	3.9035844						
						123283	426.666479						
CBL-460 Loop Sleeve		Purchased	No			130	Each	515.0000	2	6		FF 13-07-18	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						GA	515						
						123283	1						
						124272	5						
						124336	54						
						125499	455						

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

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Page 2

Work Order ID: 104736  
 Parent Item: D3371-041  
 Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/17/2013

Required Date: 7/19/2013

Start Qty: 3.00

Required Qty: 3.00

D2728-7	Manufactured	No	22554	120	Each	0.0000
Dart Logo label						
D3371-1	Manufactured	No		120	Each	12.0000
Pedal Lock Base						

0 3 FF 13-07-18  
 1 3 FF 13-07-18

Location	Loc Qty	Loc Code
ST490	4	
95152	4	
ST490A	8	
70040	1	
89347	2	
91950	3	
94914	2	

20  
 1

D3371-3	Manufactured	No		120	Each	7.0000
Pedal Lock Cover						

1 3 FF 13-07-18

Location	Loc Qty	Loc Code
ST490A	7	
89340	4	
91942	3	

3

D3373-7	Manufactured	No		120	Each	60.0000
Cam Lock						

1 3 FF 13-07-18

Location	Loc Qty	Loc Code
ST040	48	
101874	48	
ST064	12	
94791	12	

3

D3384-1	Manufactured	No		130	Each	18.0000
Cyclic Sock						

1 3 FF 13-07-18

Location	Loc Qty	Loc Code
ST492	18	
100750	13	
96111	5	

3

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Shop Packet Print

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# Picklist Print

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Work Order ID: 104736

Parent Item: D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/17/2013

Required Date: 7/19/2013

Start Qty: 3.00

Required Qty: 3.00

D3385-3 Manufactured No 120 Each 31.0000 1 3 FF 13-07-18  
Hinge

Location Loc Qty Loc Code

ST042 31

22387 31

HX-81 Purchased No 140 Each 157.0000 1 3

1/4"-20 SHCS 3/8" long

Location Loc Qty Loc Code

ST285 157

123436 87

123499 70

FF 13-07-18

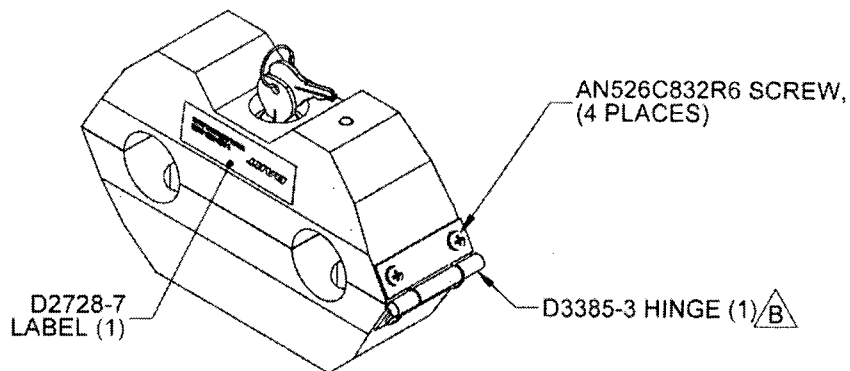
Wednesday, July 17, 2013 10:54:59 AM

Shop Packet Print

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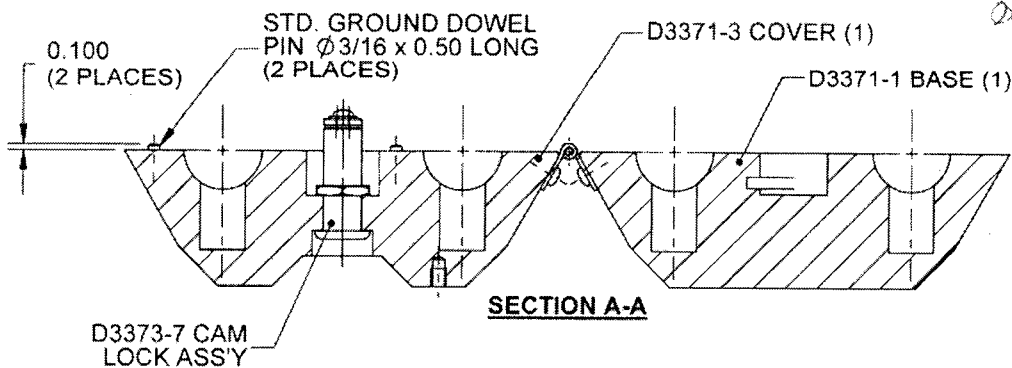


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3371</b>	REV. B SHEET 1 OF 4
DATE <b>05.03.22</b>		TITLE <b>PEDAL LOCK</b>	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



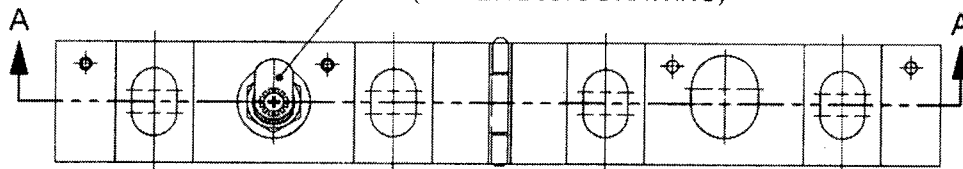
**PEDAL LOCK SHOWN LOCKED WITH KEY**

**RELEASED**  
*[Signature]*  
05/04/28



D3371-5 CAM (1),  
AND SQUARE WASHER SPACER (1),  
EXTERNAL TOOTH LOCK WASHER (1),  
#10-32 UNF PAN CROSS HEAD SCREW (1)  
(AS PER D3373 DRAWING)

*10477260*



**D3371-051 PEDAL LOCK ASSEMBLY**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

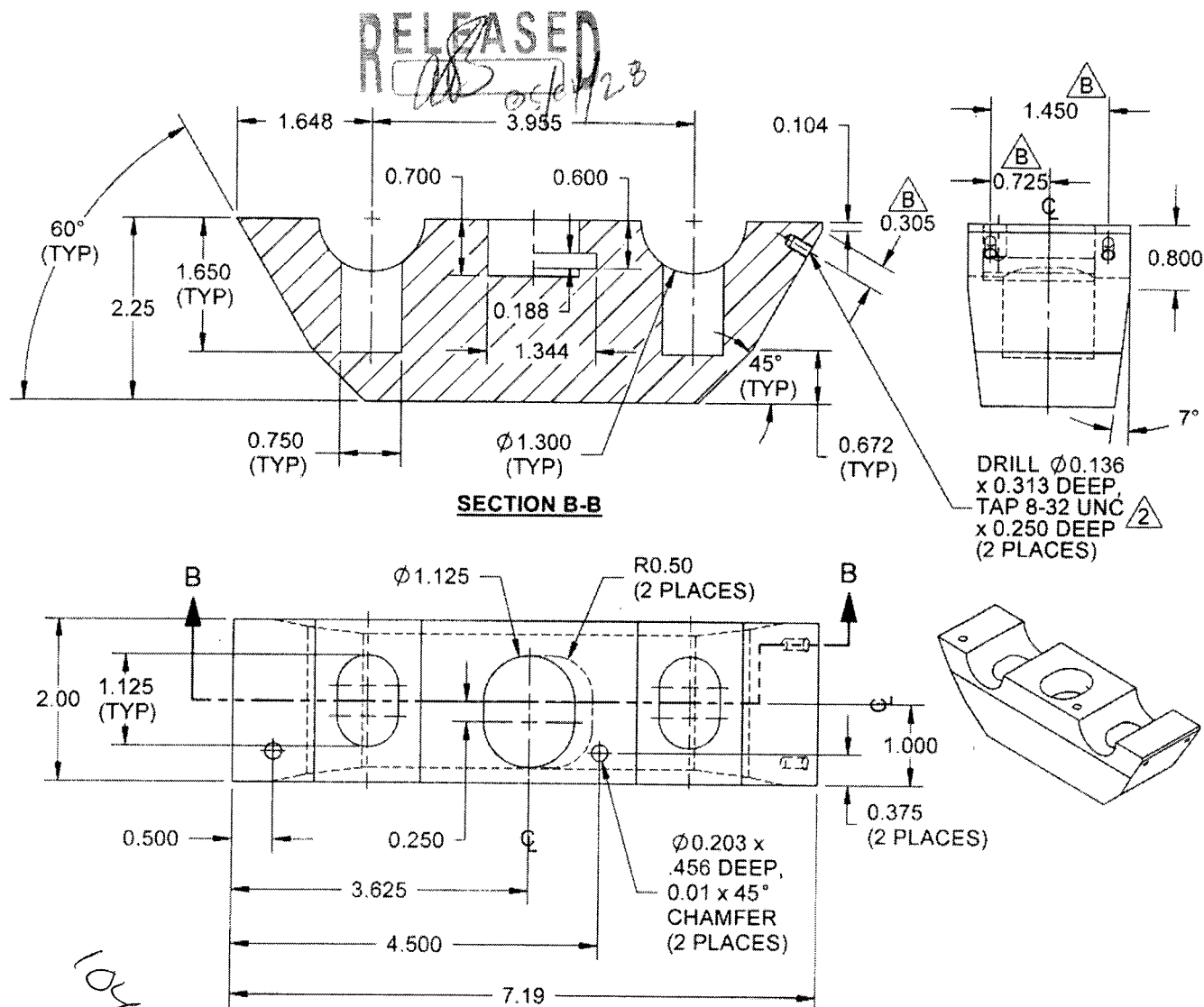
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DESIGN #5	DRAWN BY #3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22	TITLE PEDAL LOCK	SCALE 1:2	



### D3371-1 BASE

#### NOTES:

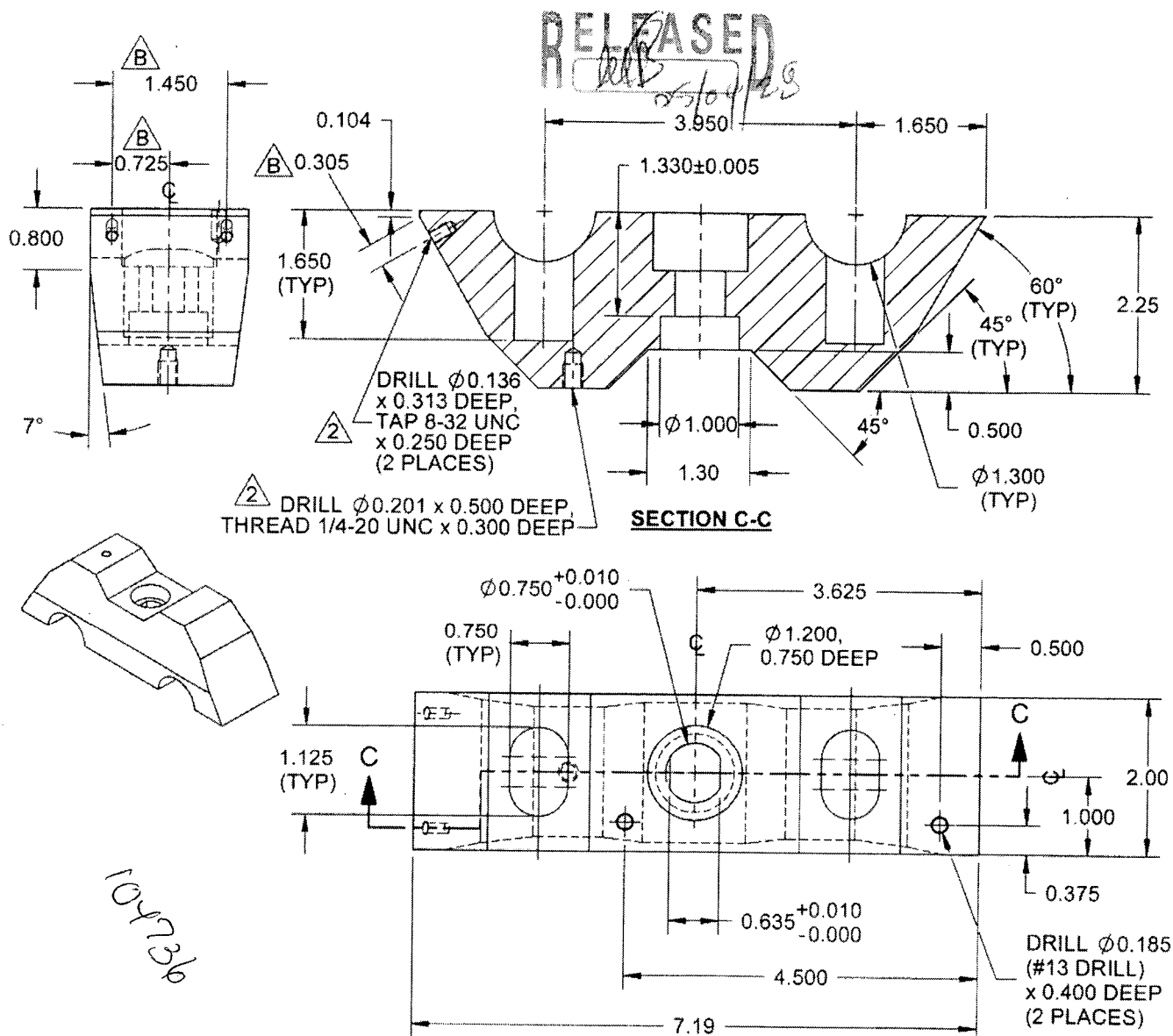
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



### D3371-3 COVER

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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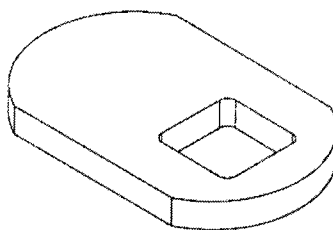
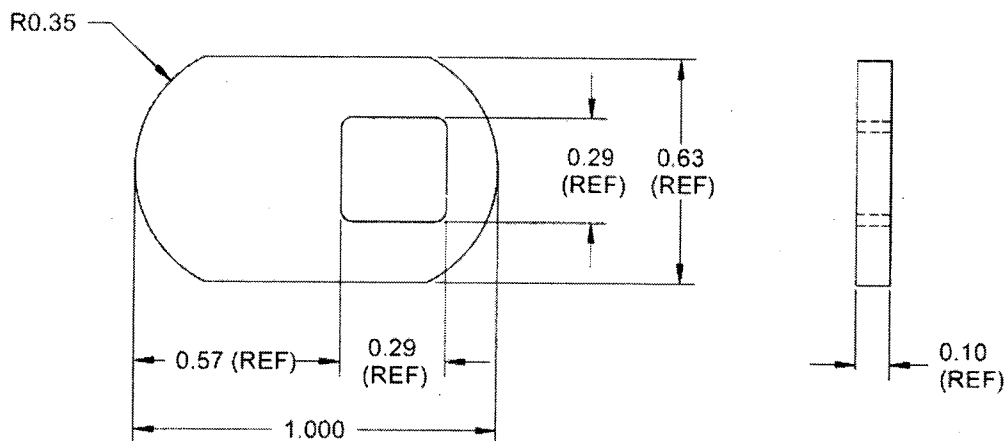
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED  
*[Signature]*  
05/04/28

## SPECIFICATION CONTROL DRAWING



104736

### D3371-5 CAM

#### NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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